

Date: Tuesday, 4/25/2006 1:55:39 PM
 User: Kim Johnston

Process Sheet

*Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD X-TUBE EXTENDED HEIGHT GEAR (-011)
Job Number	: 26840		
Estimate Number	: 10007		
P.O. Number	: N/A	Part Number	: D205596101
This Issue	: 4/25/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D205-596-101 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 23238	Drawing Revision	: A
	Type : LANDING GEAR	Material	: N/A
Written By	: _____	Due Date	: 5/31/2006
Checked & Approved By	: <i>[Signature]</i> 06.04.25	Qty:	1 Um: Each
Comment	: Est Rev G Removed Bending 05-10-25 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy D205-594 bluefile & type labels per PPP D205-596-101 CHG001

KS 05.12 (1)

2.0	D2889	FWD Crosstube
-----	-------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

FWD Crosstube

Pick:

Qty Part number Description Batch

1 D2889 Fwd Crosstube

B22533

DP06-4-25

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

2- Mark 31.53" for cutting from tangential line in the straight section from D2889 as per Dwg wall template.

1- form as per Dwg D2889

DP06-4-25

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Comformity check and sign off by engineering.

06.05.08

5.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-101

DP06-5-8

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and end of tube.

Batch # on one

06-05-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 1:55:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE EXTENDED HEIGHT GEAR (-011)

Job Number: 26840

Part Number: D205596101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



fm 06-05-2006



Comment: HAND FINISHING RESOURCE #1

Touch up ends of the tube with Chemical Conversion Coat per QSI 005 4.1

7.0

QC5

INSPECT WORK TO CURRENT STEP



Joe 05-31 (1)

Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M 08 18 V



Comment: HAND FINISHING RESOURCE #1

Prime inside and outside with Immron per QSI 005 4.2

MLM 08 08 21

(1)

9.0

QC14

Inspect Spray Paint



Joe 08-22 (1)

Comment: Inspect Spray Paint

10.0

D2856600851

Abrasion Strip



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Abrasion Strip

Pick:

Qty Part number Description Batch

2 D2856-600-851 Abrasion Strip

B24328

RT 06-08-28

11.0

D28931

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Support

Pick:

Qty Part number Description Batch

2 D2893-1 Support

B27475

RT 06-08-28

12.0

MS2192024

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-24 Clamp

M19349

RT 06-08-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 1:55:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE EXTENDED HEIGHT GEAR (-011)

Job Number: 26840

Part Number: D205596101

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg D205-596-101. Torque clamps to 80-100 in lb. Seal edges of support using Sikaflex

21 06-08-28

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 6-8-29

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-101

Location: _____

Rev K 6/4/29 (1)

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/30 (1)

Job Completion



C L 06/08/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

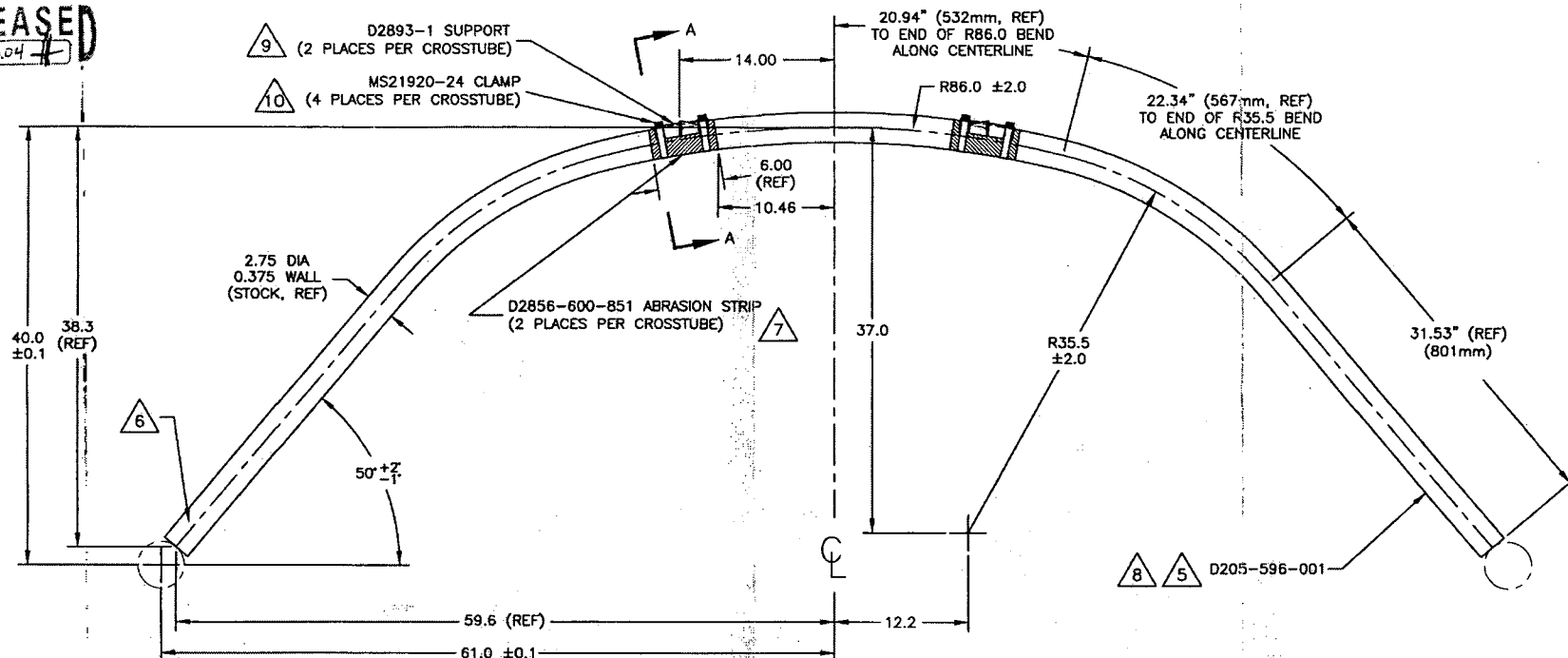
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

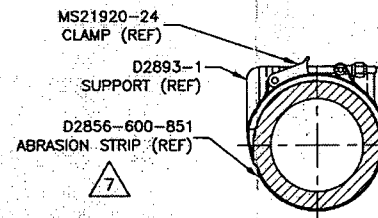
NOTE: Date & initial all entries

RELEASED
02.06.04



GENERAL NOTES:

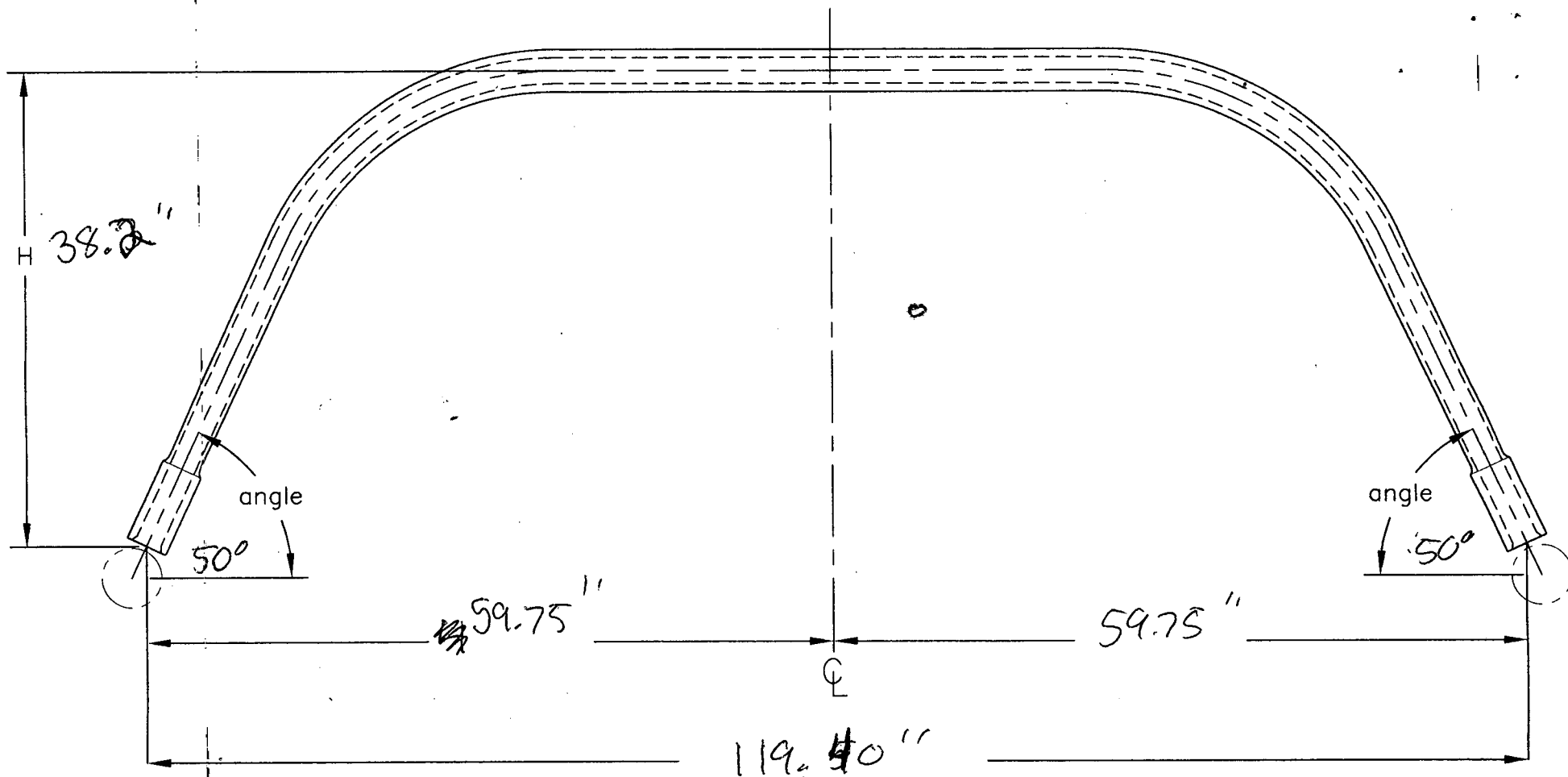
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURE FROM D6005-180
FINISHED LENGTH = 149.60
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 6) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 7) INSTALL D2856-600-851 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2893-1 SUPPORT, PER QSI 035
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/-291 SEALANT (OPTIONAL)
- 10) TORQUE CLAMPS 80 TO 100 IN-LB



SECTION A-A
SCALE 2:5

A		02.05.27	NEW ISSUE	
DESIGN	✓	DRAWN BY	CP	
CHECKED	✓	APPROVED	✓	
DATE	02.05.27	TITLE	XTUBE ASS'Y (HI-HI FWD)	
COPYRIGHT © 2002 BY DART AEROSPACE LTD.		DART AEROSPACE LTD.		REV. A
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		DRAWING NO. D205-596-101		SHEET 1 OF 1
				SCALE 1:10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
26870



DATE: 06-05

DESCRIPTION: D205-596-101 Rev A

BATCH NO: 26840

DRAWING: D205-596-101 Rev A

H: 38.3

1/2 SPAN: 59.6

TOTAL SPAN: 119.2

ANGLE: 50°

[Signature] 0605-04

15

7

100

5

10